

ship 18/09

Work Order ID 107039

\*107039\*

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September-16-13 11:21:35 AM

Item ID: D4647-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Doubler

Start Date: 9/16/13 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 9/18/13 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 13-09-14 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4647	B

110

0.00

\*110\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-CUT AS PER DWG

DWG REV: B

PROG REV: B

2- Deburr

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Memo

0.00

Quality Control

8 0 Ac 13.09.18

8 0 Ac 13.09.18

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Item ID:	D4647-3	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>
Revision ID:					Stop	<b>*NS2*</b>
Item Name:	Doubler					
Start Date:	9/16/13	Start Qty: 4.00	<b>*4*</b>	Cust Item ID:		
Required Date:	9/18/13	Req'd Qty: 4.00	<b>*4*</b>	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 DAS 27 9-89 13 9 18				8			
140 <b>*140*</b> Brake NC Brake NC	Bend as per dwg  Memo	0.00 0.00				8			8 13/09/13
150 <b>*150*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 DAS 27 9-89 13 9 18				8			

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\*107039\*

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September-16-13 11:21:35 AM

Item ID: D4647-3 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Doubler  
 Start Date: 9/16/13 Start Qty: 4.00 \*4\* Cust Item ID:  
 Required Date: 9/18/13 Req'd Qty: 4.00 \*4\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				0	26	13-9-19	
170 *170* QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 DAS 16 9-89 0.00 13/09/19				8			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: ST118  Memo	0.00  0.00				8X	28	13-09-20	

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September-16-13 11:21:35 AM

Item ID: D4647-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Doubler

Start Date: 9/16/13

Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 9/18/13

Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

MW 13-09-20

MW 13-09-20

# Picklist Print

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Page 1

Work Order ID: 107039

Parent Item: D4647-3

Parent Item Name: Doubler

Start Date: 9/16/13

Required Date: 9/18/13

Start Qty: 4.00

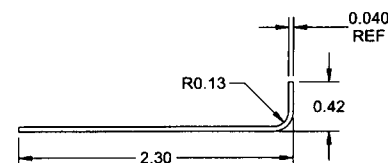
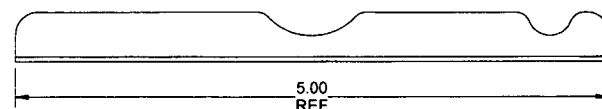
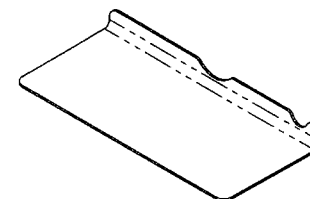
Required Qty: 4.00

Comments: IPP REV:A 12.08.29 NEW ISSUE DD VERF:JFS  
DWG REV.B DD VERF:JLM

IPP REV:B 13.07.17 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			110	sf	264.5670	0.45	1.8947368		13.09.18	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT021		264.567							
				m126350		264.567							
								126350 → 3.78					





**D4647-3 DOUBLER**

107039MCS  
13-09-16

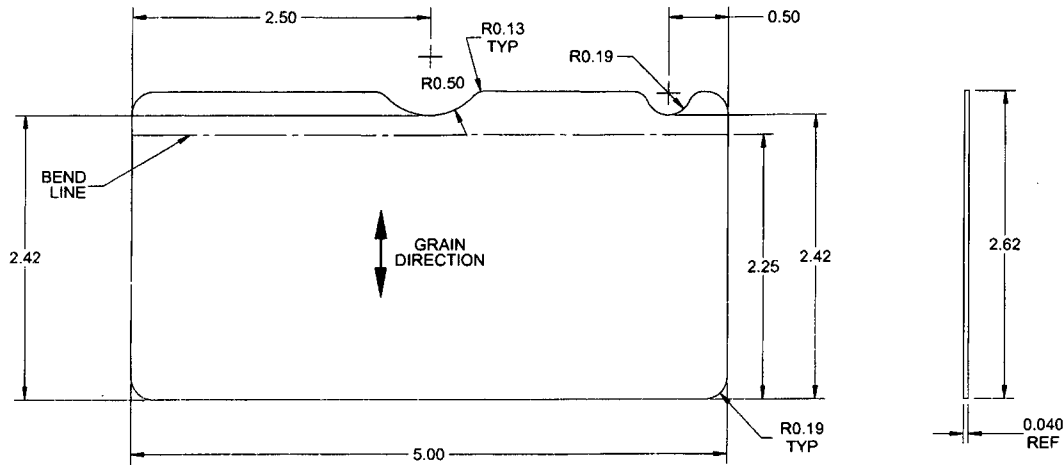
**RELEASED**  
2013-07-15

**NOTES:**

- 1) MATERIAL: MAKE FROM D4647-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4647</b>	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>DOUBLER</b>	NTS
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107035



**D4647-3F FLAT PATTERN DOUBLER**

**RELEASED**  
2013-07-15  
*WJP*

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.040
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.05 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>DC</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>DS</i>	<b>D4647</b>	SHEET 4 OF 8
APPROVED	<i>SH</i>	TITLE	SCALE
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